



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2281
Job Sheet 189709



Part No: D2281

Job Qty: 60 pcs

Part Name: Jack Saddle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/29/19

Job Tracking No:

Due Date: 2/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV G IPP Rev:A Removed from 9 Digit 05-12-02 JLM IPP: rev B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	60 pcs		2/15/19	0.00	3.14	Waterjet - Flow		OK 17/02/15
120	QC 8	60 pcs		2/15/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 38		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		DAS SC/ 68 9/02/19
							QC 8 - 67		9-89
							QC 8 - 1 (A)		DAS
140	Small Fab - Brake NC - B4B	60 pcs		2/15/19	0.01	1.51	Small Fab - Brake - 1 - B4B		30 9-89 19/02/19
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 - B4B		
150	QC 5	60 pcs		2/15/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		

Plex 1/29/19 2:51 PM Dart.lajeunesse.marie

					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 38	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	PD 19.02.23
					QC 5 - 50	
					QC 5 - 30	
160	Packaging 3-1 - Stock - B4B	60 pcs	2/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	FL
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170	QC 21 - SA	60 pcs	2/15/19	0.00 0.00	QC 21 - SA - 21	DAS 21 FEB 28 2019
					QC 21 - SA - 70	9-69
Part Op 100 - 1-Cut as per Dwg Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2-Deburr if necessary Descriptions: 120 - (QC8- Inspect parts - second check) 140 - Form as per D2281 using D2281-T2 150 - (QC5- Inspect part completeness to step on W/O) 160 - (Identify as per dwg & Stock Location: <u> </u>) LOCATION : WA001-1 170 - (QC21- Final Inspection - Work Order Release)						

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S14GA	304SS sheet .080	7.5000 sf (.125 ea)	100-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S14GA	8	6	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Jack Saddle	4.468Inches ± 0.010	4.478 4.458		
2	Jack Saddle	4.114Inches ± 0.010	4.124 4.104		
3	Jack Saddle	2.933Inches ± 0.010	2.943 2.923		
4	Jack Saddle	1.535Inches ± 0.010	1.545 1.525		
5	Jack Saddle	0.354Inches ± 0.010	0.364 0.344		
6	Jack Saddle	0.354Inches ± 0.010	0.364 0.344		
7	Jack Saddle	0.604Inches ± 0.010	0.614 0.594		
8	Jack Saddle	2.000Inches ± 0.010	2.010 1.990		
9	Jack Saddle	3.396Inches ± 0.010	3.406 3.386		
10	Jack Saddle	3.646Inches ± 0.010	3.656 3.636		
11	Jack Saddle	4.000Inches ± 0.010	4.010 3.990		
12	Jack Saddle	1.525Inches ± 0.010	1.535 1.515		
13	Jack Saddle	2.475Inches ± 0.010	2.485 2.465		
14	Jack Saddle	0.323Inches + 0.006 - 0.001	0.329 0.322	Diameter	
15	Jack Saddle	0.080Inches ± 0.010	0.090 0.070		

Plex 1/29/19 2:51 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hemel Hempstead, Herts
Herts AL3 7JY
UK
TEL: 01438 832-8200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S154401

Part: D2281

Job No: 189709

Serial No/Batch: S154401

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/5/19